

Split

Work Order ID 117817

July-16-14 1:56:57 PM

117817

Page 1

Item ID: D2842-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Step Assembly, 206 Float

Stop *NS2*

Start Date: 5/05/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 4-07-16 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2842	Rev B
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100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8271 as per Dwg D2842 ***DO NOT OPEN HOLES***
3-Deburr and bevel ends for welding

8 DMC 14-7-16

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

5 14-08-11

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Item ID: D2842-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly, 206 Float

Start Date: 5/05/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Large Fab	Weld per dwg A/R Aluminum rod Batch: <i>125091</i> Large Fab <i>128316</i>	0.00				<i>5</i>	<i>0</i>		<i>14.08.12</i>
	Memo	0.00							
	1- Weld one end cap and (2) lugs using Jig DT10038 as per Dwg D2842								
	2- Grind end cap weld flush								
	3- Open hole as per dwg and deburr								
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00				<i>5</i>		AUG 12 2014	DAS 24 9-89
	Memo	0.00							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				<i>5</i>		AUG 12 2014	DAS 24 9-89
	Memo	0.00							

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 5/05/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						5		4-8-13	PMC
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160						5	0		R
QC	Memo	0.00							14.08.14
Quality Control									
170	Weld per dwg A/R Aluminum rod Batch: 125091	0.00							
170						5	0		R
Large Fab	Memo	0.00							14.08.14
Large Fab	1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.								

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 5/05/14 Start Qty: 8.00 ***g*** Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 8.00 ***g*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC10- Inspect visual per QSI004- ground welds	0.00							
180							(5)	14-08-18	DAS 9 9-89
QC	Memo	0.00							
Quality Control									
190	QC5- Inspect part completeness to step on W/O	0.00							
190							(5)	14-08-18	DAS 9 9-89
QC	Memo	0.00							
Quality Control									
191	Pressure Wash per QSI005 4.3	0.00							
191							5	7/6/14-8-18	
HandFinish	Memo	0.00							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								

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Item ID: D2842-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 5/05/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:05 OVEN TEMPERATURE: 320 FINISH TIME: 11:35								
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control									
220	HandFinishing	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: 11124817								

DAS 34 9-89

DAS 15 9-89

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Item ID: D2842-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 5/05/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00						⑤ 14-08-22	DAS 9 9-89
Quality Control									
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo	0.00						14/8/27 ⑤	DAS 9 9-89
Packaging	ppr 12 3823 123821								
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00						MLJ 14-08-27	
Quality Control								MLJ 14-08-27	

D206 628023 +4
633 +4

Picklist Print

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Work Order ID: 117817

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C		Manufactured	No			120	Each	91.0000	1	8			
										**	JMK 14-07-16		
D2622-120C													
Step Extrusion													

Location	Loc Qty	Loc Code
HALL	32	
109575	32	
WA003	59	
101765	1	
<u>115141</u>	58	

D2734		Manufactured	No			120	Each	123.0000	2	16			
										**	B 119286 → 16x Jk		
D2734													
Step End Plate													

Location	Loc Qty	Loc Code
WA003	123	
119286	86	
119498	36	
99709	1	

D3459-1		Manufactured	No			220	Each	9.0000	2	16			
										**	B 121120 → 10x Jk		
D3459-1													
Float Step Mounting Plate													

Location	Loc Qty	Loc Code
WA003	9	
113244	9	

Picklist Print

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Work Order ID: 117817

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 8.00

Required Qty: 8.00

D3459-3 Manufactured No 120 Each 14.0000 2 16

D3459-3

Float Step Mounting Plate

**

14.08.14

Location

Loc Qty

Loc Code

WA003

14

116810

14

113052

MS27039C1-07

Purchased

No

220

Each

83.0000

3

MS27039C1-07

screw

**

10
24 15
3/13/14
14.08.20

Location

Loc Qty

Loc Code

ST308

83

124580

6

m127305

27

m128401

50

NAS1149C0332R

Purchased

No

100

Each

5,228.000

3

NAS1149C0332R

WASHER

**

x15
24 15
3/19/14
14.08.20

Location

Loc Qty

Loc Code

GA

809

125654

809

Return2014

41

122063

41

ST279

600

m129390

600

ST292

628

125654

8

m128591

620

st510

3150

m126319

61

m127306

2500

m127410

563

m127831

26

14129909
x15

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Shop Packet Print

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Picklist Print

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 8.00

Required Qty: 8.00

NAS1329C3KB130

Purchased

No

220

Each

76.0000

3

NAS1329C3KB130

Insert

24 15 *af* 3/19/14 *u* 11/08/12

Location

Loc Qty

Loc Code

FP001

51

m126410

1

m127836

50

ST

25

296

25

NAS1515H3L

Purchased

No

220

Each

467.0000

3

***NAS1515H3I ***

Washer

24 15 *af* 3/19/14 *u* 11/08/12

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

427

m127831

155

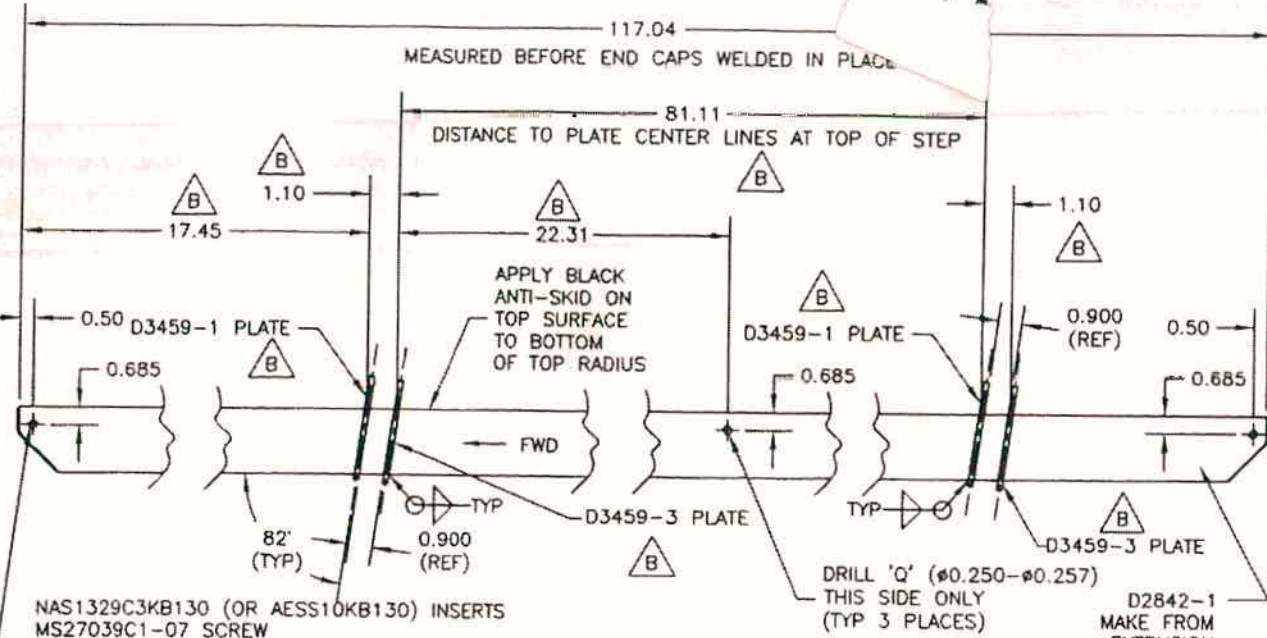
m128976

272

15

DART

1178711
14-05-06
REFER TO STEP
END DETAIL



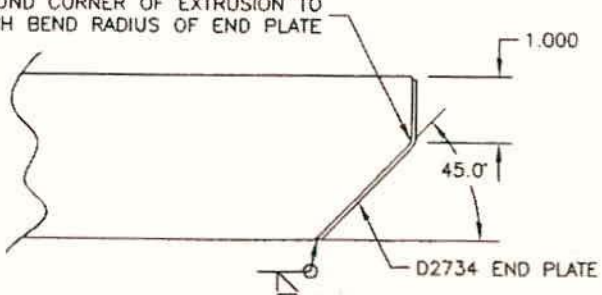
NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

05-11-14
RELEASED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.09.23	DRAWING NO.	D2842	REV. B
		TITLE	206L/407 FLOAT STEP ASSEMBLY	SHEET 1 OF 1
		SCALE	NTS	
	A		98.10.13	
	B		05.09.23	RE-DESIGN, ADD D3459-1/-3

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